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D2739**Job Sheet 208945****Part No:** D2739**Job Qty:** 4 pcs**Part Name:** 350 I-Beam**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/7/20**Job Tracking No:****Due Date:** 4/30/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per revE DD verf:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	4 pcs	4/29/20		0.00	4.64	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	4 pcs	4/29/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1-1 Chemical-B4B	4 pcs	4/30/20		0.00	0.80	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		



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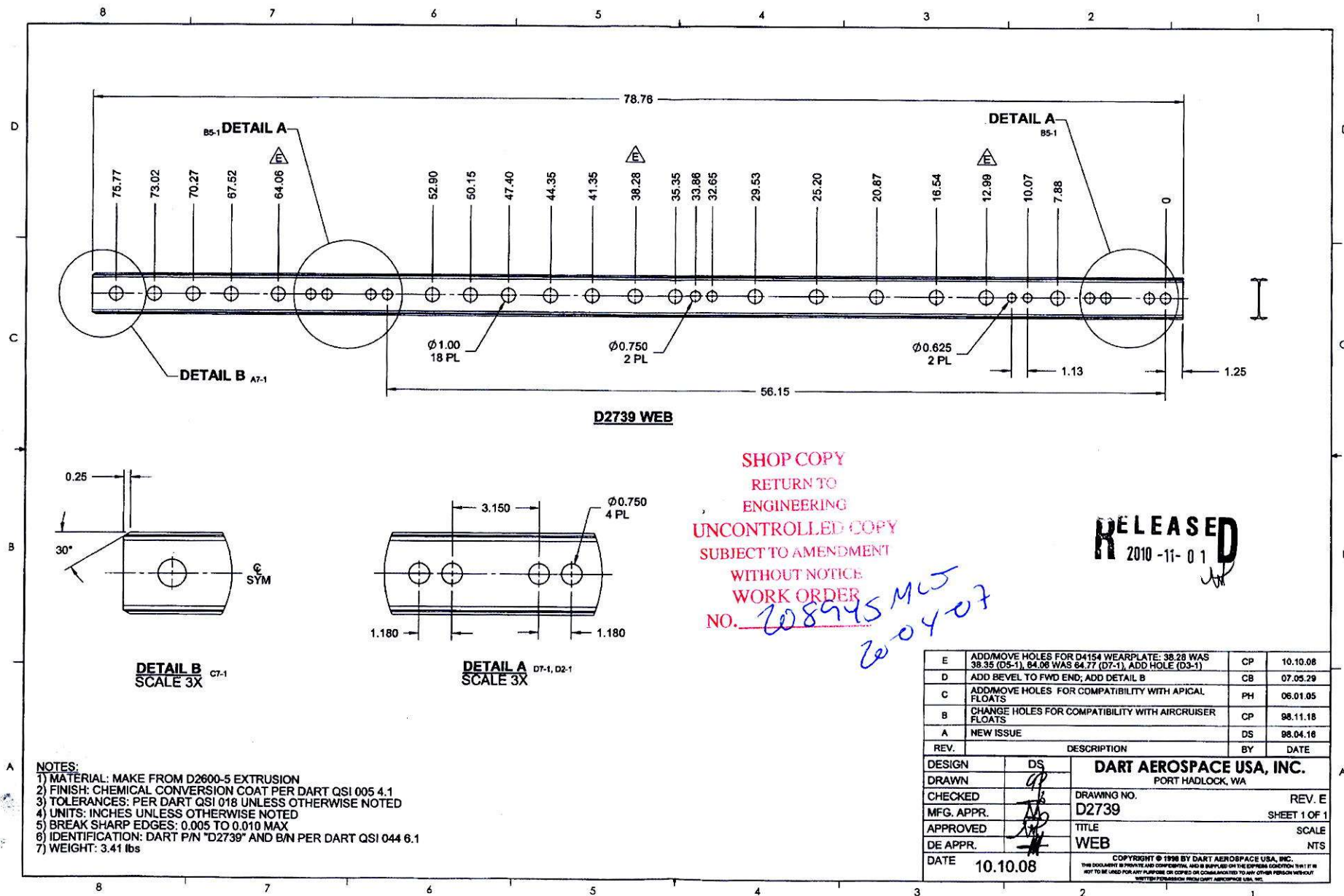
Container No: S273172**Part:** D2739**Job No:** 208945**Serial No/Batch:** S273172**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 6/24/20

Plex 4/7/20 8:37 AM Dart.lajeunesse.marie

Plex 4/7/20 8:37 AM Dart.lajeunesse.marie

140 Packaging 3-1 - Stock - B4B	4 pcs	4/30/20	0.00 0.00	QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	DAS				
Packaging 3 - 35 - B4B	03				
Packaging 3 - 36 - B4B	9-89				
Packaging 3 - 37 - B4B					
150 QC 21 - SA	4 pcs	4/30/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 100 - (Skidtubes) 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Descriptions: Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends. 110 - QC5- Inspect part completeness to step on W/O 120 - (Chemical Conversion Coat per QSI005 4.1) 130 - (QC7- Inspect Chemical Conversion Coat) 140 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2600-5-108	Extrusion I-Beam Thin	4 pcs (1 ea)	100-Skidtubes - 1	5146203	

Job Allocations				
Operation 100-Skidtubes - 1	Component Part D2600-5-108	Required 4	Inventory 98	Allocated 0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type Special Comments
1	Web	78.760Inches ± 0.030	78.790 78.730	
2	Web	1.180Inches ± 0.010	1.190 1.170	
3	Web	3.150Inches ± 0.010	3.160 3.140	
4	Web	1.180Inches ± 0.010	1.190 1.170	
5	Web	0.250Inches ± 0.030	0.280 0.220	
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle
7	Web	1.250Inches ± 0.030	1.280 1.220	
8	Web	7.880Inches ± 0.030	7.910 7.850	
9	Web	10.070Inches ± 0.030	10.100 10.040	
10	Web	12.990Inches ± 0.030	13.020 12.960	
11	Web	16.540Inches ± 0.030	16.570 16.510	
12	Web	20.870Inches ± 0.030	20.900 20.840	
13	Web	25.200Inches ± 0.030	25.230 25.170	
14	Web	29.530Inches ± 0.030	29.560 29.500	
15	Web	32.650Inches ± 0.030	32.680 32.620	
16	Web	33.860Inches ± 0.030	33.890 33.830	
17	Web	35.350Inches ± 0.030	35.380 35.320	
18	Web	38.280Inches ± 0.030	38.310 38.250	
19	Web	41.350Inches ± 0.030	41.380 41.320	
20	Web	44.350Inches ± 0.030	44.380 44.320	
21	Web	47.400Inches ± 0.030	47.430 47.370	
22	Web	50.150Inches ± 0.030	50.180 50.120	
23	Web	52.900Inches ± 0.030	52.930 52.870	
24	Web	64.060Inches ± 0.030	64.090 64.030	
25	Web	70.270Inches ± 0.030	70.300 70.240	
26	Web	73.020Inches ± 0.030	73.050 72.990	
27	Web	75.770Inches ± 0.030	75.800 75.740	
28	Web	56.150Inches ± 0.030	56.180 56.120	



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SUBJECT TO AMENDMENT
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WORK ORDER
NO. *208945 MJS*
200407

RELEASED
2010-11-01

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (DS-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>	DRAWING NO. D2739 REV. E SHEET 1 OF 1 TITLE WEB SCALE NTS	
DATE	10.10.08	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					